

Work Order ID 105857

105857

Page 1

August-22-13 11:12:14 AM

Item ID: D2739

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 350 I Beam

Start Date: 8/22/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/05/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-08-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject - Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

100

Skidtubes

Skidtubes

0.00

Skidtubes

Memo:

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

D/B

13-8-22

D.D.

13/8/23 (4)

SAD

1715-2 (1)

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(4) JB 13-08-23

140

Identify as per dwg & Stock Location: LG

0.00

140

Packaging

Memo

0.00

Packaging

(9) SAD 13-08-23

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 13-08-23

MLJ 13-08-23

Picklist Print

Page 1

August-22-13 11:12:18 AM

Work Order ID: 105857

105857

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 8/22/13

Required Date: 9/05/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rcv: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured No

Each

42.0000

4

D2600-5-108

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

42

73909

2

90684

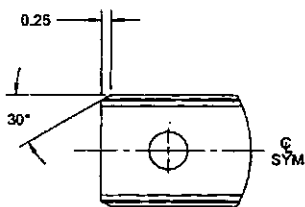
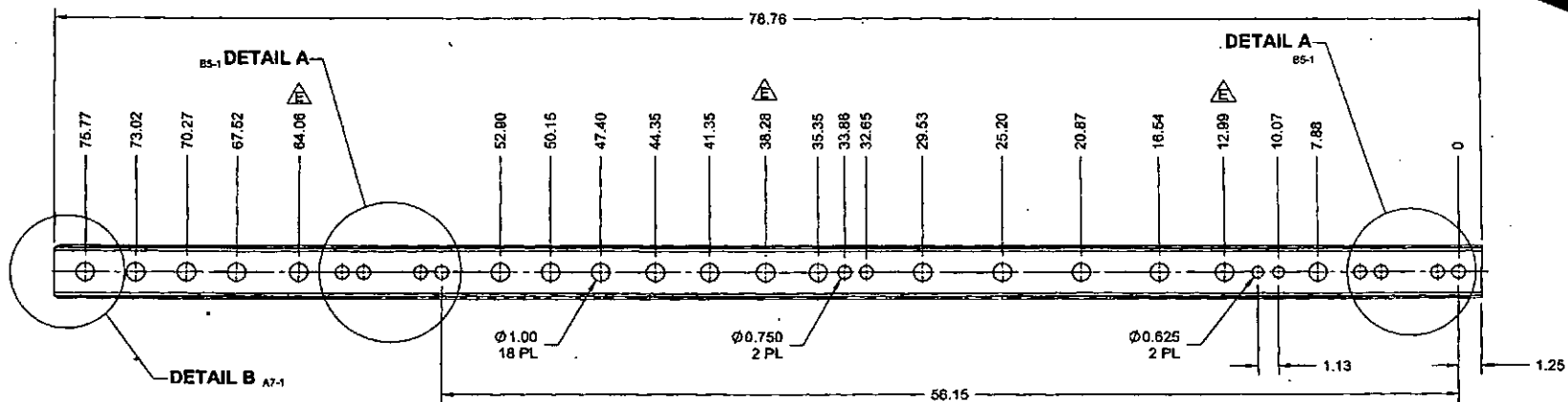
40

4

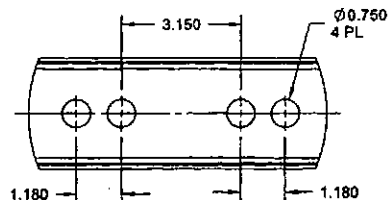
13-8-22

DA
SAU





DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

SHOWN
UNCONTROLLED
SUBJECT TO
WITH
V. 2

105857 MLS
13-08-22

RELEASED
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	08.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUISER FLOATS	CP	08.11.18
A	NEW ISSUE	DS	08.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	DP		
CHECKED	DP	DRAWING NO.	REV. E
MFG. APPR.	DP	D2739	SHEET 1 OF 1
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED BY THE DART AEROSPACE USA, INC. FOR THE U.S. GOVERNMENT FOR ANY PURPOSE. NO COPYRIGHT OR OTHER RIGHTS ARE CLAIMED IN THIS DOCUMENT. THE U.S. GOVERNMENT IS AUTHORIZED TO REPRODUCE AND TRANSMIT THIS INFORMATION IN ANY FORM AND BY ANY MEANS.	

